

Split

Work Order ID 68343-1

Tuesday, April 12, 2011 10:06:46 AM



Page 1

Item ID: D3405-043

Accept



Setup

Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 4/12/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

HP

Date: 11-04-12 Tooling:

Date:

Run

Start



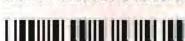
QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr | | | | | | | | |
|----------|--------------|--|--|--|--|--|--|--|--|
|----------|--------------|--|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-------|-------|--|--|--|--|--|--|--|--|
| D3405 | Rev B | | | | | | | | |
|-------|-------|--|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-----|----------------|------|--|--|--|--|--|--|--|
| 100 | FLOW WATER JET | 0.00 | | | | | | | |
|-----|----------------|------|--|--|--|--|--|--|--|

| | | | | | | | | | |
|----------|------|------|--|--|--|--|--|--|--|
| Waterjet | Memo | 0.00 | | | | | | | |
|----------|------|------|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-------------------|--|--|--|--|--|--|--|--|--|
| FLOW CNC Waterjet | 1-Cut as per Dwg D3405 Dwg Rev Prog Rev 2-Deburr if necessary | | | | | | | | |
|-------------------|--|--|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|

| | | | | | | | | | |
|----|------|------|--|--|--|--|--|--|--|
| QC | Memo | 0.00 | | | | | | | |
|----|------|------|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-----------------|--|--|--|--|--|--|--|--|--|
| Quality Control | | | | | | | | | |
|-----------------|--|--|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-----|-----------------------------------|------|--|--|--|--|--|--|--|
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
|-----|-----------------------------------|------|--|--|--|--|--|--|--|

| | | | | | | | | | |
|----|------|------|--|--|--|--|--|--|--|
| QC | Memo | 0.00 | | | | | | | |
|----|------|------|--|--|--|--|--|--|--|

| | | | | | | | | | |
|-----------------|--|--|--|--|--|--|--|--|--|
| Quality Control | | | | | | | | | |
|-----------------|--|--|--|--|--|--|--|--|--|

UV

11-04-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 68343

Split



Page 2

Tuesday, April 12, 2011 10:06:46 AM

Item ID: D3405-043

Revision ID:

Item Name: Lug Assembly

Start Date: 4/12/2011 Start Qty: 10.00



Setup

Start



Stop



Required Date: 4/18/2011 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

130



Brake NC

Brake NC

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

SB 1105102

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

SB 1105102

H2

150



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch *M107057* 0.00

Large Fab

Memo

0.00

Weld as per Dwg D3405 use DT8484
Identify as D3405-043

2 11-5-26 X4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

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NOTE: Date & initial all entries

Work Order ID 68343

Tuesday, April 12, 2011 10:06:46 AM



Page 3

Item ID: D3405-043

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 4/12/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC9- Inspect visual per QS1004- Fusion Welds

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

G. Cross.26

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*8/11/11**(74)*

0.00

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00

11/16/964

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*8:15
110
8:45**11/11/5-27.*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 68343

Tuesday, April 12, 2011 10:06:46 AM



Page 4

Item ID: D3405-043

Revision ID:

Item Name: Lug Assembly

Start Date: 4/12/2011 Start Qty: 10.00

Required Date: 4/18/2011 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



Packaging

Packaging

Identify as per dwg & Stock Location

Y74

0.00

0.00

4 6 34/1103(2)

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

11/5/27 Q4 SP

11/15/30 SP

MF

11-05-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 10:06:52 AM

Page 1

Work Order ID: 68343



Parent Item: D3405-043



Parent Item Name: Lug Assembly

Start Date: 4/12/2011

Required Date: 4/18/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A 05.09.01 New issue KJ/JLM
IPP B 09.01.28 Rev b dwg EC verified by: DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|---------|--|--------------|----|--|--|-----|------|---------|---|----|--|--|--|
| D3404-1 | | Manufactured | No | | | 100 | Each | 30 0000 | 1 | 10 | | | |
|---------|--|--------------|----|--|--|-----|------|---------|---|----|--|--|--|



GIW Lug

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|-------|----|--|
| WA030 | 30 | |
|-------|----|--|

| | | |
|-------|----|--|
| 67127 | 30 | |
|-------|----|--|

| | | | | | | | | | | | | |
|-----------|--|-----------|----|--|--|-----|----|--------|-------|----------|----|--|
| M304S11GA | | Purchased | No | | | 150 | sf | 6 0000 | 0.154 | 1.621053 | 7. | |
|-----------|--|-----------|----|--|--|-----|----|--------|-------|----------|----|--|



304/316 0.125 Sheet

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|--------|---|--|
| MAT020 | 6 | |
|--------|---|--|

| | | |
|--------|---|--|
| 116623 | 6 | |
|--------|---|--|

EL 11-5-26

1311-4-27

12

117494

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

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|--------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 68343 |
| Description: GHW Bracket | Part Number: | D3405-3 |
| Inspection Dwg: D3405 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|---------|-------------|----------|---------------------|-----|
| Measured by: | R | Audited by: | S | Prototype Approval: | N/A |
| Date: | 11-4-27 | Date: | 11/11/27 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|---|
| A | 06.09.01 | New Issue P/O D3405-043 | KJ/JLM |  |
| B | 09.05.04 | Dimensions update per Dwg Rev. B | KJ/DD |  |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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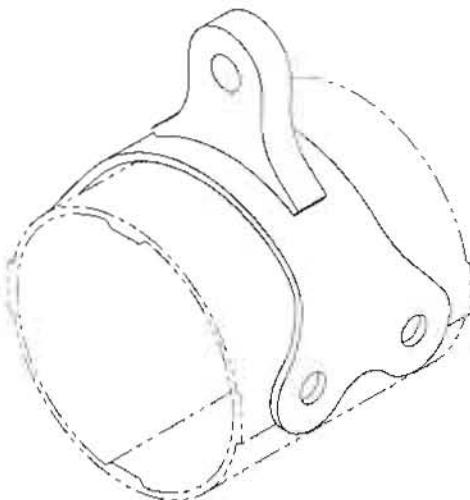
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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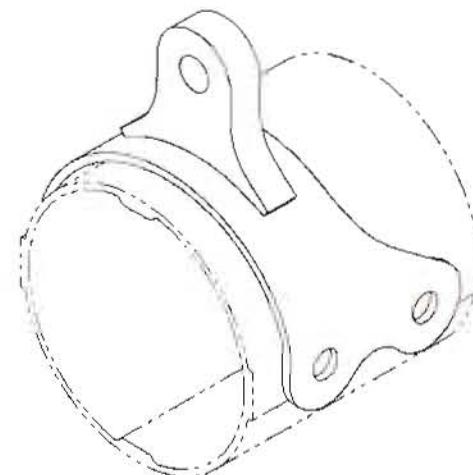
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 48343
211-09-12

| ITEM No. | QTY. -041 | QTY. -043 | PART NUMBER | DESCRIPTION |
|----------|-----------|-----------|-------------|--------------|
| 1 | X | | D3405-041 | LUG ASSEMBLY |
| 2 | | X | D3405-043 | LUG ASSEMBLY |
| 11 | 1 | 1 | D3405-1 | GHW LUG |
| 12 | 1 | 1 | D3405-1 | GHW BRACKET |
| 13 | | 1 | D3405-3 | GHW BRACKET |



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
01/11/18 M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

| | | | | | |
|----------|---|----------------------------|--------------|--|----------|
| B | DRAWN REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATH LENGTH HAS BEEN INCREASED IN LENGTH TO PREVENT FOLDING AT INSTL (SEE PAR196; SHEETS 3 & 4 ZONE A&B 4 1/2 DIM WAS 4 1/10) | | | AJS | 08.09.19 |
| A | NEW ISSUE | PH | REV. 0 | BY | DATE |
| REV. | DESCRIPTION | | | | |
| DESIGN | PH | DART AEROSPACE LTD | | | |
| DRAWN | AJS | HAWTHORPE, ONTARIO, CANADA | | | |
| CHECKED | | DRAWING NO | REV. B | | |
| MFG APPR | | D3405 | SHEET 1 OF 4 | | |
| APPROVED | | TITLE | SCALE | | |
| DE APPR | | GHW LUG ASSEMBLY | NTS | | |
| DATE | 08.09.19 | | | COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE COPIED OR DISSEMINATED WITHOUT EXPRESS WRITTEN APPROVAL | |

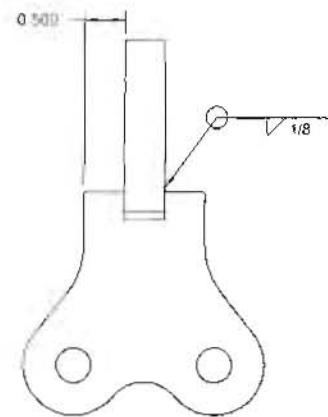
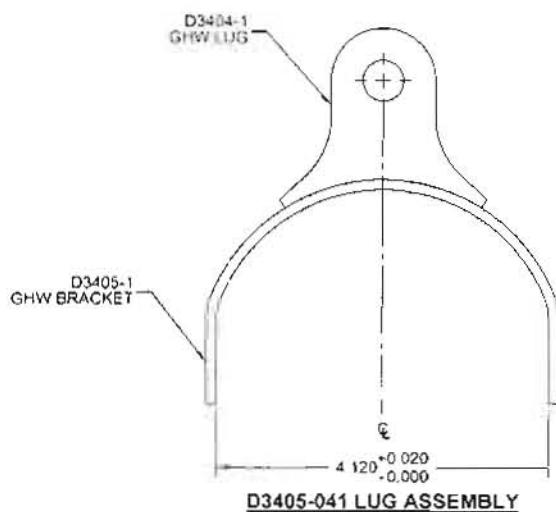
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

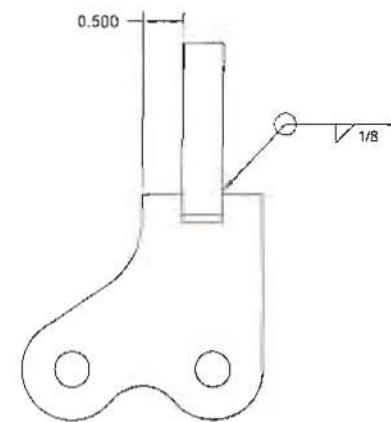
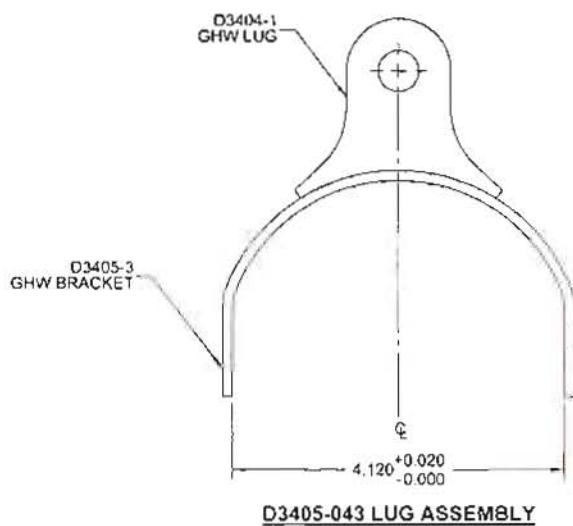
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NOTE: Date & initial all entries



W068343



RELEASED
Dart Aerospace

| | | | |
|----------|----------|--|--|
| DESIGN | PH | DART AEROSPACE LTD | |
| DRAWN | AIS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | |
| MFG APPR | | REV. B | |
| APPROVED | | D3405 | |
| DE APPR | | SHEET 2 OF 4 | |
| DATE | 08.09.19 | TITLE | |
| | | SCALE | |
| | | NTS | |
| | | GHW LUG ASSEMBLY | |
| | | COPYRIGHT © 2009 BY DART AEROSPACE LTD | |

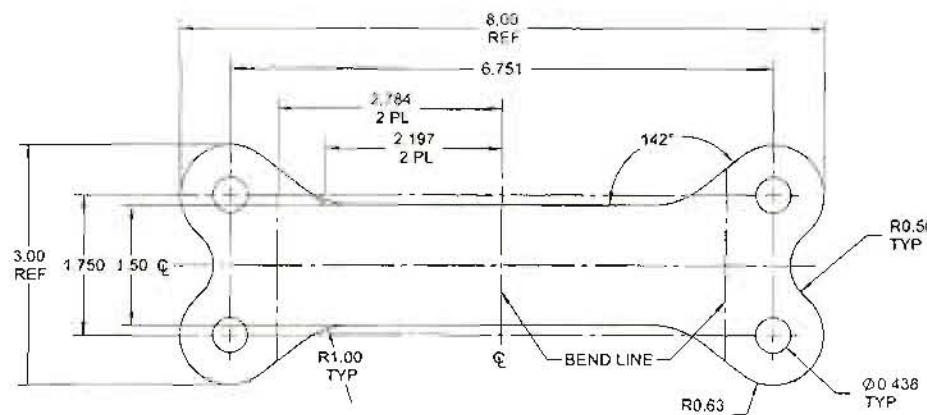
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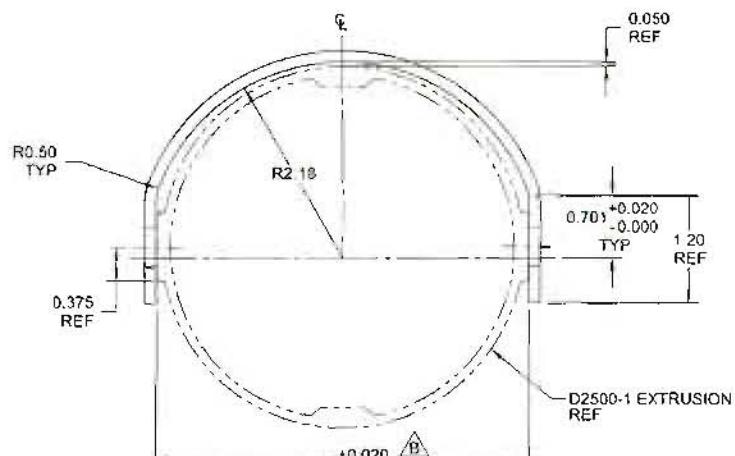
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NOTE: Date & initial all entries

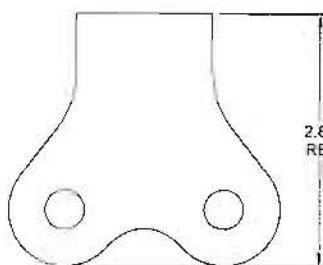


W0 68343

D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF DART SPEC M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

| | | | |
|-----------|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR | | D3405 | SHEET 1 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR | | GHM LUG ASSEMBLY | NTS |
| DATE | 08.09.19 | Copyright © 2018 by DART Aerospace Ltd. This document contains neither recommendations nor conclusions of the Government of Canada. It has been produced for internal purposes only. | |

RELEASED
MP 28/n/b

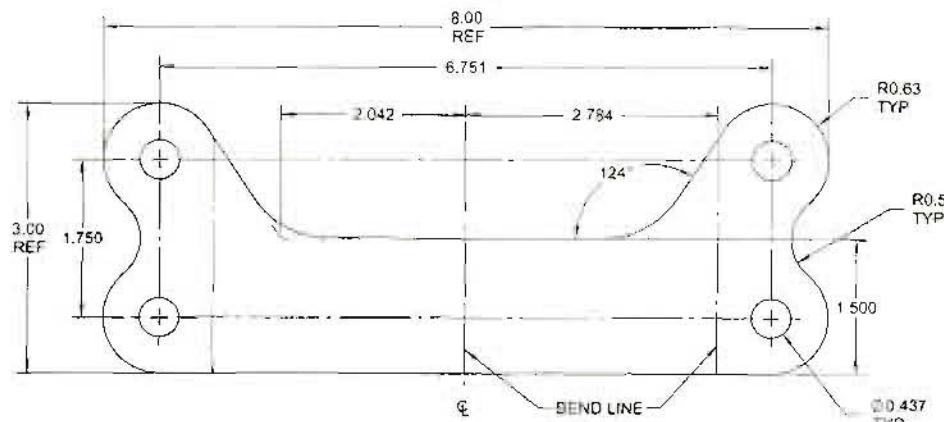
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

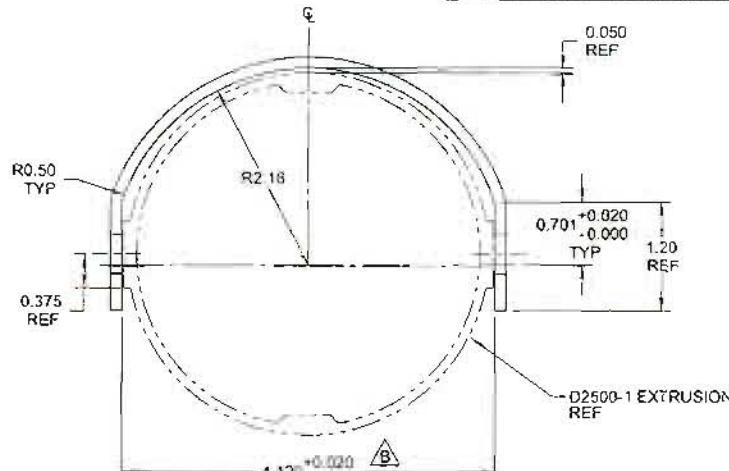
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



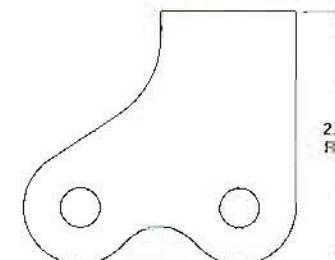
D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF DART SPEC M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A



SIDE VIEW FOR REF ONLY

RELEASED
06/12/18 M

| DESIGN | PH | DART AEROSPACE LTD | |
|----------|----------|-----------------------------|--------------|
| DRAWN | A/S | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | REV. B | |
| MFG APPR | | D3405 | SHEET 4 OF 4 |
| APPROVED | | | |
| DB APPR. | | | |
| DATE | 08.09.19 | | RTS |

GHW LUG ASSEMBLY

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries